

Work Order ID 149380

July 22, 2016 3:09:13 PM

149380

Page 1

Item ID: D3463-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Weldment Assembly
 Start Date: 8/5/2016 Start Qty: 8.00 *8* 78A Cust Item ID:
 Required Date: 8/15/2016 Req'd Qty: 8.00 *8* 78A Customer:
 Reference:

Approvals: Process Plan: 50 Date: 7/25/16 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3463	Rev B								
100	Large Fab	0.00							
100									
Large Fab	Memo	1.59							
Large Fab	Weld assembly as per dwg D3463 using DT8875 ***Leave a small none welded area on each side bottom of D3463-3 step to drain water***								
	134442								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.03							
Quality Control									

Amoia
DCG

7 16-10-18
JBL

⑦ 16-10-20 DAS
9
9-89

⑦ 16-10-20 DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 149380

July 25, 2016 2:20:55 PM

149380

Page 2

Item ID: D3463-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment Assembly
Start Date: 8/5/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/15/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
131	Spray Painting per QSI005 4.2	0.00							
131									
SprayPaint	Memo	0.00				7			
Spray Painting	PRIME AS PER QSI005 PRIME BATCH <u>135654</u>								23.10.16
	PAINT AS PER QSI 005 DRAB GREEN BATCH <u>135836</u>								
132	QC14- Inspect Spray Paint	0.00							
132									
QC	Memo	0.00				x7	d	ll	16/10/20
Quality Control									
140	Wing Walk as per dwg QSI005 4.4 Batch <u>M13550</u>	0.00							
140									
HandFinish	Memo	0.20				x7	d	ll	16/10/20
Hand Finishing									

DAS
15
9-89

Work Order ID 149380

July 25, 2016 2:20:55 PM

149380

Page 3

Item ID: D3463-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 8/5/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 8/15/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				7			DAS 36 9-89 OCT 27 2016
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.01				7x			DAS 36 9-89 16/11/07
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.13							DAS 21 9-89 NOV 07 2016
									DAS 21 9-89 NOV 07 2016

Picklist Print

July 22, 2016 3:09:12 PM

Page 1

Work Order ID: 149380

149380

Parent Item: D3463-042

D3463-042

Parent Item Name: Step Weldment Assembly

Start Date: 8/5/2016

Required Date: 8/15/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV. A 05.11.18 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806 *238-806* SS DOWEL PIN 1" LONG		Purchased	No			100	Each	42.0000	2	16			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002 135623			42		14			
					M127628			42					
D3453-3 *D3453-3* Clevis		Manufactured	No			100	Each	14.0000	1	8			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002 149348			14		7			
					121222			3					
					121924			11					
D3453-5 *D3453-5* Plug		Manufactured	No			100	Each	5.0000	1	8			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002 149370			5		7			
					132561			1					
					147404			4					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

July 22, 2016 3:09:12 PM

Page 2

Work Order ID: 149380

149380

Parent Item: D3463-042

D3463-042

Parent Item Name: Step Weldment Assembly

Start Date: 8/5/2016

Required Date: 8/15/2016

Start Qty: 8.00

Required Qty: 8.00

D3463-1

Manufactured No

100

Each

8.0000

1

8

D3463-1

Arm

******16-10-12
JALLocationLoc QtyLoc Code

WA001

7

146737

3

146896

4

WA002

1

134861

1

D3463-3

Manufactured No

100

Each

6.0000

1

8

D3463-3

Step

******16-10-17
JALLocationLoc QtyLoc Code

WA002

6

146876

6

D3463-5

Manufactured No

100

Each

7.0000

2

16

D3463-5

End Cap

******16-10-17
JALLocationLoc QtyLoc Code

WA002

7

146909

7

D3463-7

Manufactured No

100

Each

6.0000

1

8

D3463-7

Drag Arm

******16-10-17
JALLocationLoc QtyLoc Code

WA002

6

146885

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

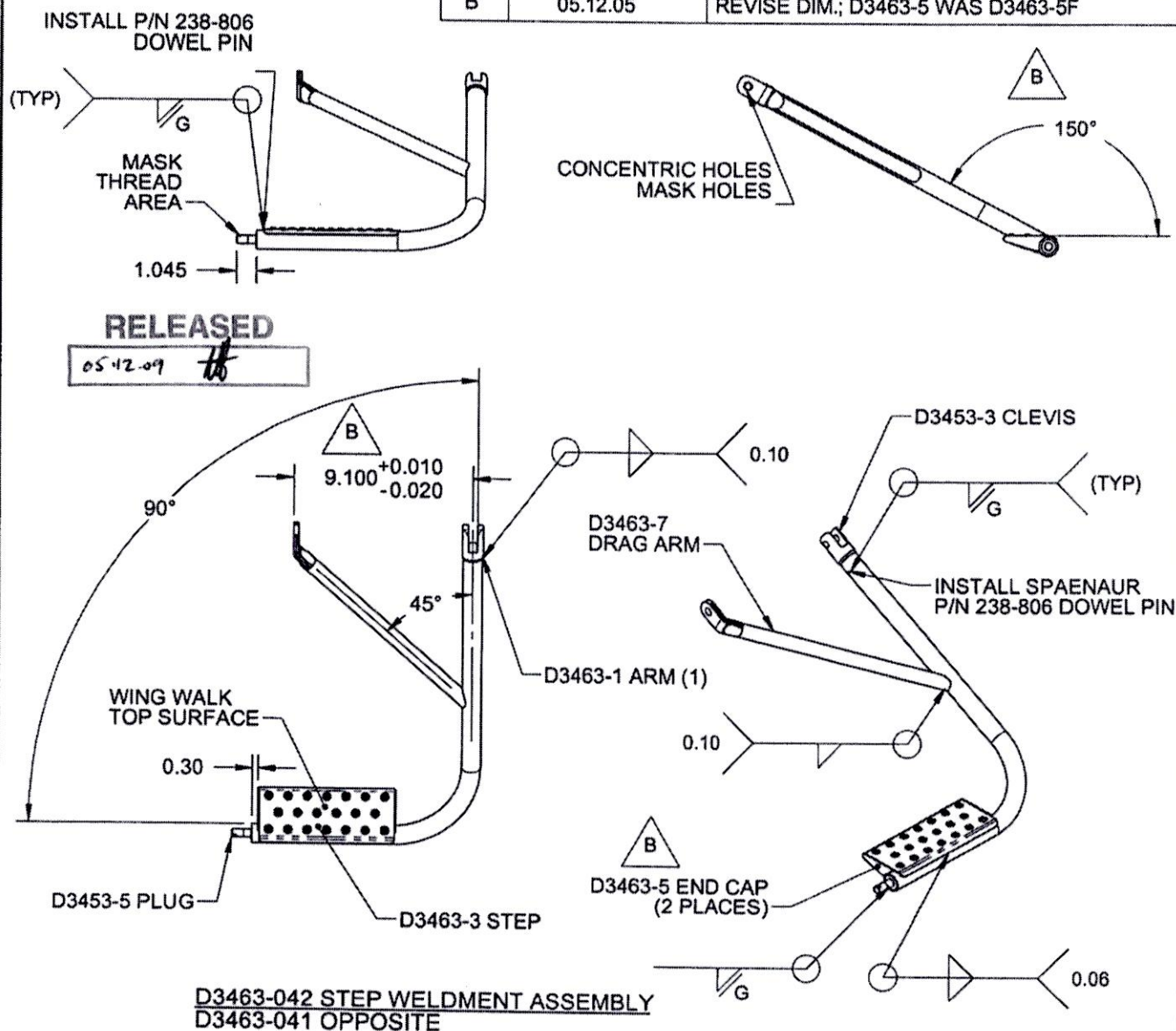
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																										
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 																																																																																																																																						
Description Work Order Deviation				Disposition																																																																																																																																										
								Completed By																																																																																																																																						
								Lead hand / Supervisor Approval Verification																																																																																																																																						
								QC / QA Coordinator Approval																																																																																																																																						
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="4" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td>Environment ☐</td> <td>☐</td> <td>No Re-verification ☐</td> <td>☐</td> <td>Pressure/Forced ☐</td> <td>☐</td> <td>Temperature/Cure ☐</td> <td>☐</td> <td>Power Loss/Surge ☐</td> <td>☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>☐</td> <td>Operator ☐</td> <td>☐</td> <td>Bending ☐</td> <td>☐</td> <td>Set-up ☐</td> <td>☐</td> <td>Folio/Program ☐</td> <td>☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>☐</td> <td>Offset/Setup ☐</td> <td>☐</td> <td>Centre Not Concentric ☐</td> <td>☐</td> <td>BOM/Route ☐</td> <td>☐</td> <td>Grain ☐</td> <td>☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>☐</td> <td>Supplier ☐</td> <td>☐</td> <td>Cracks ☐</td> <td>☐</td> <td>Broken/Damage/Defect ☐</td> <td>☐</td> <td>Weld ☐</td> <td>☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>☐</td> <td>Training ☐</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>☐</td> <td>Wrong Stock Pulled ☐</td> <td>☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>☐</td> <td>Use for Testing ☐</td> <td>☐</td> <td>Cuffs ☐</td> <td>☐</td> <td>Contamination ☐</td> <td>☐</td> <td>Out of Sequence ☐</td> <td>☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>☐</td> <td>Poor Information ☐</td> <td>☐</td> <td>Crushing ☐</td> <td>☐</td> <td>Countersink ☐</td> <td>☐</td> <td>Off-set ☐</td> <td>☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>☐</td> <td>Rushing ☐</td> <td>☐</td> <td>Heat Treat ☐</td> <td>☐</td> <td>Cut Too Short ☐</td> <td>☐</td> <td>Mislabeled ☐</td> <td>☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>☐</td> <td>Product Improvement ☐</td> <td>☐</td> <td>Wave/Twist in Tube ☐</td> <td>☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>☐</td> <td>Fit/Function ☐</td> <td>☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>☐</td> <td>Process Improvement ☐</td> <td>☐</td> <td>Marks/Chatter ☐</td> <td>☐</td> <td>Drill Holes ☐</td> <td>☐</td> <td>Misaligned/off center ☐</td> <td>☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>☐</td> <td>Manufacturing Process ☐</td> <td>☐</td> <td colspan="7" rowspan="2" style="text-align: center; vertical-align: middle;"> OTHER : _____ </td> </tr> <tr> <td>Misidentified ☐</td> <td>☐</td> <td>Past Due ☐</td> <td>☐</td> </tr> </tbody> </table>										Root Cause				FAULT CATEGORY				Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐	☐	Positioned Wrong ☐	Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐	☐	Outside Dimensions ☐	Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐	☐	Over/Under tolerance ☐	Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐	☐	Part Incorrect ☐	Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐	☐	Part Lost/Missing ☐	Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐	Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐	Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐	LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐	Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐	Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____							Misidentified ☐	☐	Past Due ☐	☐
Root Cause				FAULT CATEGORY																																																																																																																																										
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐	☐	Positioned Wrong ☐																																																																																																																																				
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐	☐	Outside Dimensions ☐																																																																																																																																				
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐	☐	Over/Under tolerance ☐																																																																																																																																				
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐	☐	Part Incorrect ☐																																																																																																																																				
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐	☐	Part Lost/Missing ☐																																																																																																																																				
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐																																																																																																																																				
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐																																																																																																																																				
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐																																																																																																																																				
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐																																																																																																																																				
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐																																																																																																																																				
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____																																																																																																																																										
Misidentified ☐	☐	Past Due ☐	☐																																																																																																																																											

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT SCALE 1:8		
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

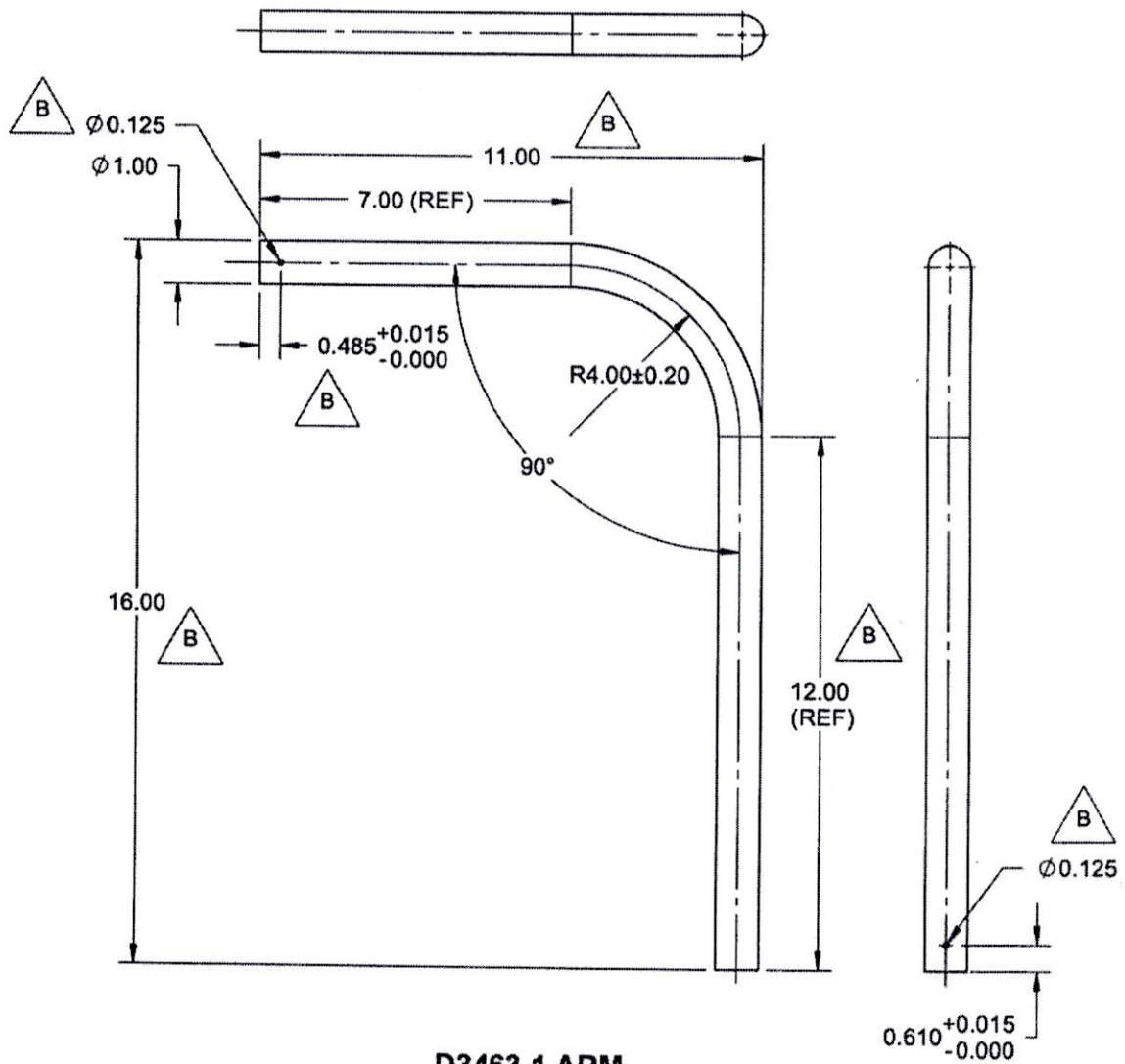
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

7/25/10
SA 149380

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.09 **D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

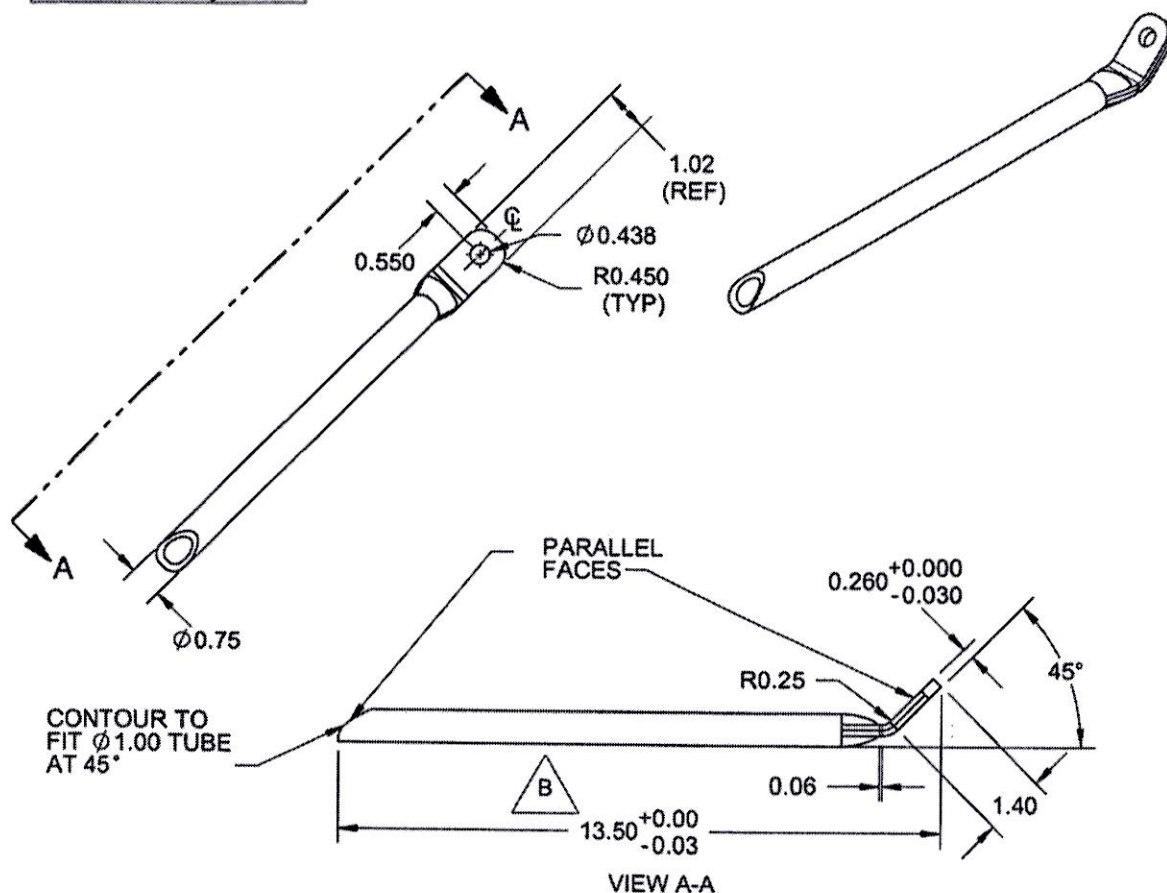
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 #



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

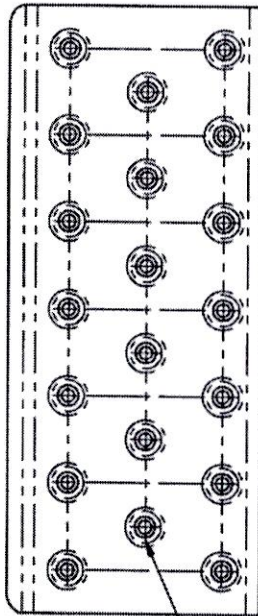
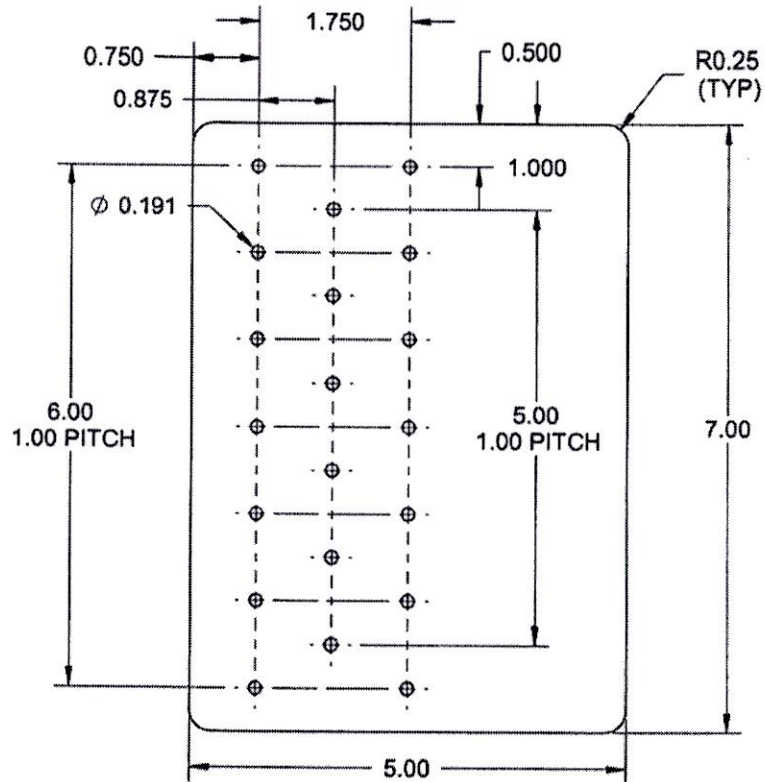
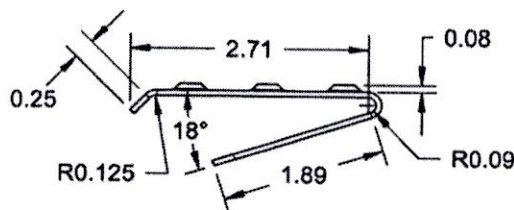
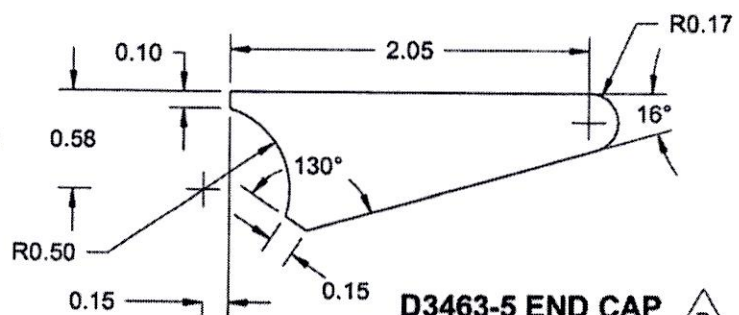
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.09 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.